

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011085**Date Inspected:** 18-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Ying Xin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 10

This QA inspector was instructed by task leaders to carry out the measurements on the stiffeners bolt hole edge to the edge of stiffener. The measurements carried out on all stiffeners of skin A, B, C, D and E of tower assembly and interior splice plates wherever accessible and recorded on the sheet. The members are identified as Tower Components. The member designations reviewed are as follows.

WEST TOWER LIFT 3 BOTTOM

SOUTH TOWER LIFT 2 ~ LIFT 3 SKIN B SPLICE PLATE

SOUTH TOWER LIFT 2 ~ LIFT 3 SKIN E SPLICE PLATE

SOUTH TOWER LIFT 2 ~ LIFT 3 SKIN C SPLICE PLATE

NORTH TOWER LIFT 2 ~ LIFT 3 SKIN B SPLICE PLATE

NORTH TOWER LIFT 2 ~ LIFT 3 SKIN D SPLICE PLATE

NORTH TOWER LIFT 2 ~ LIFT 3 SKIN C SPLICE PLATE

NORTH TOWER LIFT 2 ~ LIFT 3 SKIN E SPLICE PLATE

WEST TOWER LIFT 2 ~ LIFT 3 SKIN D SPLICE PLATE

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EAST TOWER LIFT 3 ~ LIFT 4 SKIN C SPLICE PLATE
EAST TOWER LIFT 3 ~ LIFT 4 SKIN A SPLICE PLATE

This Quality Assurance (QA) Inspector observed the following work in progress:

Bay 10

TOWER STRUT PLATE

SMAW welding of weld joint 43 located on ND1-A6002-8.
Welder is identified as 056364. ZPMC CWI is identified as Mr. Chen Ying Xin.
The welding variables recorded by QC appeared to comply with WPS-B-T-2112.

SOUTH TOWER LIFT 2 SKIN B MOUNTING PLATE

SMAW welding of weld joint 8 located on CAMPSA-2A/B.
Welder is identified as 067589. ZPMC QC is identified as Mr. Sun Tian Liang.
The welding variables recorded by QC appeared to comply with WPS-B-P-2114.

NORTH TOWER LIFT 4 D/E CORNER

FCAW welding of weld joint 3A located on NSTL4-3B/L.
Welder is identified as 066733. ZPMC QC is identified as Mr. Li Peng Fei.
The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U2b-F.

NORTH TOWER LIFT 5 BEARING PLATE

SMAW welding of weld joint 4B located on ND1-BPSA5-3.
Welder is identified as 052930. ZPMC QC is identified as Jiang La Mei.
The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
